Section 1. Registration Information

Source Identification

Facility Name:	Ajinomoto North America, Inc.
Parent Company #1 Name:	Ajinomoto North America, Inc.
Parent Company #2 Name:	Ajinomoto Co., Inc.

Submission and Acceptance

Submission Type:	Re-submission
Subsequent RMP Submission Reason:	5-year update (40 CFR 68.190(b)(1))
Description:	
Receipt Date:	23-May-2014
Postmark Date:	23-May-2014
Next Due Date:	23-May-2019
Completeness Check Date:	23-May-2014
Complete RMP:	Yes
De-Registration / Closed Reason:	
De-Registration / Closed Reason Other Text:	
De-Registered / Closed Date:	
De-Registered / Closed Effective Date:	
Certification Received:	Yes

Facility Identification

EPA Facility Identifier:	1000 0004 9119
Other EPA Systems Facility ID:	52553JNMTS1AJIN

Dun and Bradstreet Numbers (DUNS)

Facility DUNS:	78427258
Parent Company #1 DUNS:	78427258
Parent Company #2 DUNS:	

Facility Location Address

Street 1:	1 Ajinomoto Drive
Street 2:	
City:	Eddyville
State:	IOWA
ZIP:	52553
ZIP4:	5003
County:	MONROE

Facility Latitude and Longitude

Latitude (decimal):	41.148611
Longitude (decimal):	-092.646389
Lat/Long Method:	Interpolation - Photo
Lat/Long Description:	Administrative Building
Horizontal Accuracy Measure:	25
Horizontal Reference Datum Name:	North American Datum of 1983
Source Map Scale Number:	24000

Owner or Operator

Operator Name:	Ajinomoto North America, Inc.
Operator Phone:	(641) 969-4561

Mailing Address

Operator Street 1:	1 Ajinomoto Drive
Operator Street 2:	
Operator City:	Eddyville
Operator State:	IOWA
Operator ZIP:	52553
Operator ZIP4:	5003
Operator Foreign State or Province:	
Operator Foreign ZIP:	
Operator Foreign Country:	

Name and title of person or position responsible for Part 68 (RMP) Implementation

RMP Name of Person:	Dave Sample
RMP Title of Person or Position:	SER Tech IV
RMP E-mail Address:	sampled@ajiusa.com

Emergency Contact

Emergency Contact Name:	Jeff Peyton
Emergency Contact Title:	General Manager
Emergency Contact Phone:	(641) 969-3310
Emergency Contact 24-Hour Phone:	(641) 969-3330
Emergency Contact Ext. or PIN:	
Emergency Contact E-mail Address:	peytonj@ajiusa.com

Other Points of Contact

Facility or Parent Company E-mail Address:	lamendolas@ajiusa.com
Facility Public Contact Phone:	(201) 292-3200
Facility or Parent Company WWW Homepage Address:	WWW.AJINOMOTO-USA.COM

Local Emergency Planning Committee

LEPC:	Monroe County LEPC

Full Time Equivalent Employees

Number of Full Time Employees (FTE) on Site:	69
FTE Claimed as CBI:	

Covered By

OSHA PSM :	Yes
EPCRA 302 :	Yes
CAA Title V:	
Air Operating Permit ID:	

OSHA Ranking

OSHA Star or Merit Ranking:

Last Safety Inspection

Last Safety Inspection (By an External Agency) Date:	03-Dec-2013
Last Safety Inspection Performed By an External Agency:	Travelers insurance

Predictive Filing

Did this RMP involve predictive filing?:

Preparer Information

Preparer Name:
Preparer Phone:
Preparer Street 1:
Preparer Street 2:
Preparer City:
Preparer State:
Preparer ZIP:
Preparer ZIP4:
Preparer Foreign State:
Preparer Foreign Country:
Preparer Foreign ZIP:

Confidential Business Information (CBI)

CBI Claimed:
Substantiation Provided:
Unsanitized RMP Provided:

Reportable Accidents

Reportable Accidents:	See Section 6. Accident History below to determine if there were any accidents reported for this RMP.

Process Chemicals

Process ID:	1000052138
Description:	MSG Manufacturing
Process Chemical ID:	1000063211
Program Level:	Program Level 3 process
Chemical Name:	Ammonia (anhydrous)
CAS Number:	7664-41-7
Quantity (lbs):	130000
CBI Claimed:	
Flammable/Toxic:	Toxic

Process NAICS

Process ID:	1000052138
Process NAICS ID:	1000052762
Program Level:	Program Level 3 process
NAICS Code:	325199
NAICS Description:	All Other Basic Organic Chemical Manufacturing

Section 2. Toxics: Worst Case

Toxic Worst ID: 1000042526

Percent Weight:	100.0
Physical State:	Gas liquified by pressure
Model Used:	EPA's RMP*Comp(TM)
Release Duration (mins):	10
Wind Speed (m/sec):	1.5
Atmospheric Stability Class:	F
Topography:	Urban

Passive Mitigation Considered

Dikes:	
Enclosures:	
Berms:	
Drains:	
Sumps:	
Other Type:	

Section 3. Toxics: Alternative Release

Toxic Alter ID: 1000045138

Percent Weight:	100.0
Physical State:	Gas liquified by pressure
Model Used:	EPA's RMP*Comp(TM)
Wind Speed (m/sec):	3.0
Atmospheric Stability Class:	D
Topography:	Urban

Passive Mitigation Considered

Dikes:	
Enclosures:	
Berms:	
Drains:	
Sumps:	
Other Type:	

Active Mitigation Considered

Sprinkler System:	
Deluge System:	
Water Curtain:	
Neutralization:	
Excess Flow Valve:	
Flares:	
Scrubbers:	
Emergency Shutdown:	
Other Type:	

Section 4. Flammables: Worst Case

No records found.

Section 5. Flammables: Alternative Release

No records found.

Section 6. Accident History

No records found.

Section 7. Program Level 3

Description

The Ajinomoto North America, Inc. ammonia release prevention program consists of the following: collecting process safety information, conducting a process hazard analysis, developing written operating procedures, training staff, conducting periodic mechanical integrity inspections, following a management of change procedure, conducting pre-start up safety reviews before starting a new covered process, conducting periodic compliance audits, investigating release incidents, facilitating employee participation, following a hot work permit procedure, and qualifying contractors.

Program Level 3 Prevention Program Chemicals

Prevention Program Chemical ID:	1000052907
Chemical Name:	Ammonia (anhydrous)
Flammable/Toxic:	Toxic
CAS Number:	7664-41-7
Prevention Program Level 3 ID:	1000044077
NAICS Code:	325199

Safety Information

Safety Review Date (The date on which the safety information was last reviewed or revised):	10-Feb-2012

Process Hazard Analysis (PHA)

PHA Completion Date (Date of last PHA or PHA update):	11-Nov-2009

The Technique Used

What If:	
Checklist:	
What If/Checklist:	Yes
HAZOP:	
Failure Mode and Effects Analysis:	
Fault Tree Analysis:	
Other Technique Used:	
PHA Change Completion Date (The expected or actual date of completion of all changes resulting from last PHA or PHA update):	01-Nov-2014

Major Hazards Identified

Toxic Release:	
Fire:	
Explosion:	
Runaway Reaction:	
Polymerization:	
Overpressurization:	Yes
Corrosion:	
Overfilling:	

Contamination:	
Equipment Failure:	
Loss of Cooling, Heating, Electricity, Instrument Air:	
Earthquake:	
Floods (Flood Plain):	
Tornado:	
Hurricanes:	
Other Major Hazard Identified:	

Process Controls in Use

Vents:	
Relief Valves:	Yes
Check Valves:	Yes
Scrubbers:	Yes
Flares:	
Manual Shutoffs:	Yes
Automatic Shutoffs:	Yes
Interlocks:	Yes
Alarms and Procedures:	Yes
Keyed Bypass:	
Emergency Air Supply:	
Emergency Power:	
Backup Pump:	
Grounding Equipment:	
Inhibitor Addition:	
Rupture Disks:	
Excess Flow Device:	Yes
Quench System:	
Purge System:	
None:	
Other Process Control in Use:	

Mitigation Systems in Use

Sprinkler System:	
Dikes:	Yes
Fire Walls:	
Blast Walls:	
Deluge System:	
Water Curtain:	
Enclosure:	
Neutralization:	
None:	
Other Mitigation System in Use:	

Monitoring/Detection Systems in Use

Process Area Detectors:	Yes
Perimeter Monitors:	
None:	
Other Monitoring/Detection System in Use:	Patrols, surveillance camera

Changes Since Last PHA Update

Reduction in Chemical Inventory:	
Increase in Chemical Inventory:	
Change Process Parameters:	
Installation of Process Controls:	
Installation of Process Detection Systems:	
Installation of Perimeter Monitoring Systems:	
Installation of Mitigation Systems:	
None Recommended:	Yes
None:	
Other Changes Since Last PHA or PHA Update:	

Review of Operating Procedures

Operating Procedures Revision Date (The date of the most recent review or revision of operating procedures):	06-Nov-2013

Training

Training Revision Date (The date of the most recent review or revision of training programs):	26-Nov-2008

The Type of Training Provided

Classroom:	Yes
On the Job:	Yes
Other Training:	

The Type of Competency Testing Used

Written Tests:	Yes
Oral Tests:	Yes
Demonstration:	Yes
Observation:	Yes
Other Type of Competency Testing Used:	

Maintenance

Maintenance Procedures Revision Date (The date of the most recent review or revision of maintenance procedures):	06-Nov-2013
Equipment Inspection Date (The date of the most recent equipment inspection or test):	19-Aug-2013
Equipment Tested (Equipment most recently inspected or tested):	PSR valves

Management of Change

Change Management Date (The date of the most recent change that triggered management of change procedures):	15-Aug-2013

Change Management Revision Date (The date of the most recent review or revision of management of change procedures):	04-Nov-2013

Pre-Startup Review

Pre-Startup Review Date (The date of the most recent pre-startup review):	13-Mar-2012

Compliance Audits

Compliance Audit Date (The date of the most recent compliance audit):	10-Feb-2012
Compliance Audit Change Completion Date (Expected or actual date of completion of all changes resulting from the compliance audit):	09-Mar-2012

Incident Investigation

Incident Investigation Date (The date of the most recent incident investigation (if any)):	10-Dec-2009
Incident Investigation Change Date (The expected or actual date of completion of all changes resulting from the investigation):	19-Jan-2012

Employee Participation Plans

Participation Plan Revision Date (The date of the most recent review or revision of employee participation plans):	04-Nov-2013

Hot Work Permit Procedures

Hot Work permit Review Date (The date of the most recent review or revision of hot work permit procedures):	04-Nov-2013

Contractor Safety Procedures

Contractor Safety Procedures Review Date (The date of the most recent review or revision of contractor safety procedures):	04-Nov-2013
Contractor Safety Performance Evaluation Date (The date of the most recent review or revision of contractor safety performance):	18-Mar-2008

Confidential Business Information

CBI Claimed:	

Section 8. Program Level 2

Section 9. Emergency Response

Written Emergency Response (ER) Plan

Community Plan (Is facility included in written community emergency response plan?):	Yes
Facility Plan (Does facility have its own written emergency response plan?):	Yes
Response Actions (Does ER plan include specific actions to be taken in response to accidental releases of regulated substance(s)?):	Yes
Public Information (Does ER plan include procedures for informing the public and local agencies responding to accidental release?):	Yes
Healthcare (Does facility's ER plan include information on emergency health care?):	Yes

Emergency Response Review

Review Date (Date of most recent review or update of facility's ER plan):	06-Jan-2014

Emergency Response Training

Training Date (Date of most recent review or update of facility's employees):	22-Nov-2013

Local Agency

Agency Name (Name of local agency with which the facility ER plan or response activities are coordinated):	Eddyville Fire Department
Agency Phone Number (Phone number of local agency with which the facility ER plan or response activities are coordinated):	(641) 969-4870

Subject to

OSHA Regulations at 29 CFR 1910.38:	Yes
OSHA Regulations at 29 CFR 1910.120:	
Clean Water Regulations at 40 CFR 112:	Yes
RCRA Regulations at CFR 264, 265, and 279.52:	Yes
OPA 90 Regulations at 40 CFR 112, 33 CFR 154, 49 CFR 194, or 30 CFR 254:	
State EPCRA Rules or Laws:	Yes
Other (Specify):	

Executive Summary

The Facility and the Regulated Substances Handled
Ajinomoto North America, Inc. is a manufacturer of food grade monosodium glutamate. Monosodium glutamate is used as a flavor enhancer. It is derived from the amino acid, glutamic acid. Glutamic acid is manufactured using an industrial fermentation process. The primary raw material for the fermentation process is glucose, which is derived from corn. The amino acid is extracted, purified, and packaged for distribution primarily in North America.

Anhydrous ammonia, which is covered under the EPA Risk Management Plan, is used at the Ajinomoto North America, Inc. facility. Ammonia is used for pH control in the fermentation process.

The Accidental Release Prevention and Emergency Response Policies at Our Facility
Ajinomoto North America, Inc. is committed protecting our employees, the public, and the environment from the risks associated with the use of hazardous industrial chemicals, including anhydrous ammonia.

We have taken steps to ensure that anhydrous ammonia is handled safely at our facility. Mechanical systems are inspected and tested to ensure safe and proper operations. Our employees are trained in the safe handling of ammonia. Approximately 75% of our employees have been trained to the HazMat Technician level, which allows quick response to any chemical release situation that may develop.

The General Accidental Release Prevention Program and Chemical-Specific Prevention Steps
Regarding anhydrous ammonia, Ajinomoto North America, Inc. is regulated under OSHA's Process Safety Management (PSM) Program and EPA's Risk Management Plan (RMP). Under these programs, we have developed and implemented procedures and we have installed equipment to help minimize the risk of an accidental release of anhydrous ammonia. These items include:
1. Periodic mechanical integrity testing of ammonia systems.
2. Periodic employee training on the hazards and safe handling of ammonia.
3. Collecting process safety information on anhydrous ammonia.
4. Conducting periodic process hazard analyses of the ammonia systems.
5. Development of written operating procedures for working with anhydrous ammonia.
6. Development of a management of change procedure for anhydrous ammonia systems.
7. Conducting pre-start up safety reviews of new processes that use anhydrous ammonia.
8. Conducting periodic compliance audits of the OSHA PSM and EPA RMP programs.
9. Promptly investigating any anhydrous ammonia release incidents and recommending changes to prevent such incidents.
10. Requiring employee participation in the development of safety programs.
11. Using hot work permits when conducting welding or cutting activities near anhydrous ammonia.
12. Qualifying contractors used to work on anhydrous ammonia systems.
13. Engineering and constructing anhydrous ammonia systems that are compliant with current engineering and industry standards.
14. Development and implementation of an Environmental Management Program under ISO 14001.
15. Administrative controls to prevent overfilling of anhydrous ammonia tanks.
16. Installation of ammonia leak sensors.
17. Installation of remote switches for emergency shutdown of the anhydrous ammonia system.

The Five-Year Accident History
In the last five years, there have been no anhydrous ammonia releases at the Ajinomoto North America, Inc. facility that meet the criteria for a reportable release as specified in 40 CFR 68.42.

The Emergency Response Program
In the event of a release of anhydrous ammonia, Ajinomoto North America, Inc. is prepared to respond.

Procedures are in place to promptly alert our employees, contractors, public safety officials, the Iowa Department of Natural Resources (IDNR), and the National Response Center in the event of a hazardous material release. We have made preparations to have the necessary safety information available for all stakeholders in the event of an accidental hazardous material release.

Ajinomoto North America, Inc. has coordinated with the Eddyville Volunteer Fire Department. The local Fire Department is aware of the hazardous chemicals used at our facility and they have toured our facility. Local industries and local emergency responders,

including the Eddyville Volunteer Fire Department, have participated in periodic drills with Ajinomoto North America, Inc.

The Ajinomoto North America, Inc. facility has coordinated with the Monroe County Local Emergency Planning Commission (LEPC) and is included in the Monroe County Emergency Operations Plan (EOP). We have coordinated with the South East Iowa Response Group (Haz Mat Team) in Ottumwa, Iowa, located approximately 17 miles away.

Ajinomoto North America, Inc. employees have been trained on haz mat response, spill reporting, and notifying the necessary public safety authorities to alert the public.

Ajinomoto North America, Inc. has the necessary equipment on site to deal with anticipated emergencies. Employees have access to and are trained in the proper use of Class A fully contained encapsulated chemical suits with self contained breathing equipment. If a haz mat release escalates, our local volunteer fire department can contact the South East Iowa Response Group (Haz Mat Team) in Ottumwa, Iowa for assistance.

Planned Changes to Improve Safety
Improving industrial chemical safety is a never ending process. We are continuously striving to improve our safety practices at Ajinomoto North America, Inc. As changes in technology, techniques, or procedures present themselves, they will be examined and considered for implementation to improve the level of our safety as related to handling anhydrous ammonia.